

CLAIMS:

1. Method of producing radially inward-protruding projections or walls (4) on the interior side (3') of tooth tips (3) constructed essentially axially with respect to the longitudinal axis on the envelope surface of an essentially cylindrical hollow body (1) in the area of the front edge of the hollow body (1), .

characterized in that, from the outside radially toward the hollow-body axis, striking or stamping processes are carried out upon the exterior side (3'') of the tooth tip (3) in the area of the front edge, the striking or stamping operations in each case being carried out on a tooth tip (3) only over a part of the width (b) of the respective tooth tip (3).

2. Method according to Claim 1,
characterized in that, in each case, only a single striking or stamping process is carried out for each tooth tip (3).

3. Method according to Claim 1 or 2,
characterized in that the striking or stamping process is carried out by means of a tool (5; 8) whose width corresponds to the width (b') of the interior surface of the respective tooth tip

(3) .

4. Method according to one of Claims 1 to 3,
characterized in that the striking or stamping process is carried
out in a centered manner in the region of the exterior surface of
the tooth tip (3) such that no intervention takes place in the
exterior tooth profile surfaces (7) of the tooth tip (3), or
these are not impaired or changed in their shape.

5. Method according to one of Claims 1 to 4,
characterized in that the striking or stamping process is carried
out by a tool which, on the one side, has a stamping surface (5")
for a strike against the exterior surface (3'') of the tooth tip
(3) as well as guiding surfaces projecting laterally over the
stamping surface (5') in the direction of the hollow body (1),
for a strike against the exterior tooth profiles (7) of the tooth
tip (3).

6. Method according to one of Claims 1 to 4,
characterized in that, before the implementation of a striking or
stamping process, a die plate (9) is applied to the tooth profile
(7) of the respective tooth tip (3) and is restored again after
the striking or stamping process has taken place.

7. Method according to one of Claims 1 to 6 for producing

walls (4) on the interior side (3') of tooth tips (3) of clutch plate carriers (1).

8. Device for implementing the method according to one of Claims 1 to 7, having a working stamp (5; 8) which can be radially applied to the exterior surface (3') of the tooth tip (3), characterized in that the effective surface (5') of the working stamp (5) has a smaller width than the width (b) of the tooth tip (3).

9. Device according to Claim 8, characterized in that the working stamp (5; 8), in addition to the effective surface (5'), has holding surfaces (9) projecting laterally over the effective surface (5'), which holding surfaces (9) correspond to the contour of the tooth tip (3) and, in the operative position of the working stamp (5), are constructed to laterally be in close contact with the tooth profiles (7) of the tooth tip (3).

10. Device according to Claim 9, characterized in that the holding surfaces (9) are constructed directly on the working stamp (8) and are non-displaceably connected with the latter, or are constructed to be separately displaceable with respect to the working stamp (8).

Translation of Figures:

Ersatzblatt (Regel 26) = replacement page (Rule 26)